

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019934**Date Inspected:** 22-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Mr. Huang Min		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Orthotropic Box Girder (OBG) Bay 5 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY # 05~08:

Flux Cored Arc Welding (FCAW) welding of welds joint CB3002K-003-031,032(CB18, BAY 6), and Welder is identified as 217185,204342. ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint BK004A1-054-043(BAY 8), and Welder is identified as 067184. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS-B-T-2232-TC-U4c-F.

Submerged Arc Welding (SAW) welding of welds joint CB3003C-019-004(CB19, BAY 6), and Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Win. The welding variables appeared to comply with the Applicable WPS-B-T-2221-B-L2C-S-2

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FCAW welding of welds joint W2-SB1-025-126~131, Welder is identified as 215689. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB1-025-112,114, Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint SA3077-004-001, Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2333-C-P2-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for

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your project.

Inspected By: Tharikoppada,Reddy

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer